

IN THE CLAIMS:

Please amend claim 25 as follows. Pursuant to 37 C.F.R. 1.121, the following is a clean copy of the amended claim. A marked-up version of claim 25 is attached as a separate sheet.

A1 25. (Amended) A composite metal product produced according to the method of claim 1.

IN THE SPECIFICATION:

Please replace paragraph 37 with the following paragraph. Pursuant to 37 C.F.R. 1.121, the following is a clean copy of the amended paragraph. A marked-up version of paragraph 37 is attached as a separate sheet.

A2 [0037] The rivet 10 shown in Fig. 10 is shown in detail in Fig. 7a. Rivet 10 includes slanted sides 72 which make an angle α with the centerline L of the rivet 10, with α being up to about 35°, preferably about 7° to about 25°. One suitable diameter d of tip 12 of the rivet 10 is about 10 mm. Rivet 10 is shown as having a rounded tip, but the tip may also be planar. Other non-limiting examples of rivets are shown in Figs. 7b-7i. Rivet 80 shown in Fig. 7b includes a cylindrical portion 82 that steps down to a first slanted side 84 which makes an angle β with the centerline L of the rivet 80 and to a second slanted side 86 which forms an angle γ with the centerline L of the rivet 80, with β being greater than angle γ . As shown in Fig. 7c, rivet 90 includes an integral flange 92 and has a pointed tip 94. Rivet 100 shown in Fig. 7d is similar to rivet 10 except that rivet 100 has a tip 102 which defines a central opening 104. Another variation of rivet 10 is shown in Fig. 7e as rivet 110 which includes an integral flange 112 having sloping sides 114 and one or more helical groove(s) 116 defined in the surface. The helical grooves 116 assist in threading the rivet 110 into a work piece and act similar to a friction stir welding tool. Rivet 120 shown in Fig. 7f is similar to rivet 110 except that integral flange 122 has straight sides 124. A partially hollow rivet 130 (similar to rivet 80) with a